Memo

Work Order ID 109835



Page 1

December-03-13 8:36:22 AM

Quality Control

Revision ID:	D3891-042 Panel Fwd LH - Sub-Co	omponent Of#D350-766		Accept	*N900	040	100)*	Setup S	Start Stop	1000	S1* S2*
		Qty: 3.00 Qty: 3.00	*3* *3*		Cust Item I	ID:						
Approvals:	Process Plan:M	Date:	: 13-12-0	STooling: SPC (Y/N):		ate:		į		Start Stop	arian area	R1* R2*
Sequence ID/ Work Center ID	Opera Descri			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp
Draw Nbr D3891 100 *100* Waterjet FLOW CNC Waterjet Grey Lexe		Memo 1-Cut as per Dwg D3 Dwg Rev:	891-2	0.00				5	0			Jm13-12-1
*110 *110*	QC2- In	spect parts off machine F/	M/FAIB	0.00				5	0			Jm13-12.

DQA:			Date:										TART
						WORK ORDER NON	-CC	ONFO	RMANCE / UPDA	TE	- 1		DARI
QA Closed:	7	7.11	Date:							Wo	rk Order up	date only	
Work Orde	er:		3			DISPOSITION		e de la companya de l	A	GAINST DE	PARTMENT/	PROCESS	
Part N NCR N	_					Rework Scrap Use-as-is Suspected Unapproved			Machining Sn moforming Fi	osstube nall Fab inishing nposite		Water Jet J. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root					Desci	ription of work order update		nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description	า	Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved							A A						
Service.							FAI	ULT CA	TEGORY				1584 1 75
Landir	ng G	ear				General		-					
		Bending Centre No Cracks Crimp/Kin Cuffs Crushing Heat Treat	k/Ripple,	/Wave		Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short		Grain Hardwa Inspect Instruct Misalig Mislabe	ion Incomplete/Unqualif tions Incomplete/Unclea gned/off center eled	fied	Outside Dime Over/Under the Part Incorrect Part Lost/Mis Part Moved Positioned W Power Loss/S	t ssing	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
ike F		nspection		Tube		Drawing		Misrea					
(2)		Marks/Ch				Drill Holes		Off-set					
ice		Furning Se				Finish		-	Calibration		/3 (E)(E		
250	- 1	Nave/Twi	ist in Tub	6		Fit/Function		Out of !	Sequence				

Work Order ID 109835

109835

Page 2

December-@3-13 8:36:22 AM

Item ID: Revision ID: D3891-042

Accept

N900040100

Setup Start

Run

Item Name: Start Date:

12/03/13

Panel Fwd LH - Sub-Component Of#D350-766-021 Start Qty: 3.00 Req'd Qty: 3.00

3

Cust Item ID:

Customer:

Reference:

Approvals:

QC:

Required Date: 12/10/13

Process Plan:

Date: Date: Tooling:

SPC (Y/N):

Date:

Date:

Start

Reject

Qty

Stop

Sequence ID/ Work Center ID

120

120

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Set Up/ Run Hours

0.00

Tool ID

Tool#

Plan Code Accept Qty

Reject Number Stamp

Insp.

130 *130* Small Fab

Small Fab

Memo

Deburr if necessary

0.00

140

Pick Kit

0.00

140

Packaging Packaging

Memo

0.00

DQA:		Date:										DAR	T
					WORK ORDER NON	-CO	ONFO	RMANCE / UPDATE		I		AEROSPAC	E
QA Closed:	707	Date:					-		Wo	ork Order up	date only		**
Work Orde	er:			10.7	DISPOSITION			AGAINS	T DEI	PARTMENT	PROCESS		
Part N			, <u>%</u>	-	Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Crosstube Machining Small Fal moforming Finishin Large Fab Composite	b g		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root			1	Descr	iption of work order update		nitial	Action		Sign &	NEW YORK		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description	Į.	Date	Verification	QC Inspector	
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved						· · · · · · · · · · · · · · · · · · ·							
第						FAI	ULT CAT	TEGORY		75° 11'%		門 报道	
Landir	Cracks Crimp/Ki Cuffs Crushing Heat Tre Inspectic Marks/C	at on Strip in	·/Wave		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruct Misalia Mislabe Misread Off-set	ion Incomplete/Unqualified tions Incomplete/Unclear gned/off center eled		Outside Dime Over/Under Part Incorrect Part Lost/Mit Part Moved Positioned W Power Loss/S	tolerance tt ssing	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other	
5		vist in Tub			Fit/Function			Sequence		1 900		505 2 3 . · · · · · · · · · · · · · · · · · ·	

Work Order ID 109835

109835

Page 3

December-03-13 8:36:22 AM Item ID:

D3891-042

Accept

N900040100

Setup Start

Panel Fwd LH - Sub-Component Of#D350-766-021 Item Name:

Stop

Start Date: Required Date: 12/10/13

Revision ID:

12/03/13

Start Qty: 3.00 Reg'd Qty: 3.00 *3*

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Tool ID

Run

QC:

Date:

SPC (Y/N):

Date:

Tool # Plan

Code

Stop

Sequence ID/ Work Center ID

150

150 Small Fab

Small Fab

Operation Description Set Up/ Run Hours

0.00

0.00

1- Bond gasket to smooth side of panel as per dwg A/R 3M 1300 adhesive Batch: 127443

160

160

Quality Control

Memo

QC5- Inspect part completeness to step on W/O

0.00

0.00

Qty

170

170

Packaging

Identify as per dwg & Stock Location:

2 13/12/2

Memo

Packaging

Accept

Reject Qty

Reject Insp. Number Stamp

DQA:			Date:										TOADT	-
						WORK ORDER NON	I-C	ONFO	RMANCE / U	PDATE			DARI	
QA Closed:			Date:				v.	5 (V 16.6)	\$100 T	W	ork Order up	date only		
Work Orde	er:					DISPOSITION	= 1	-"	Con	AGAINST DE	PARTMENT	/PROCESS		
Part I					_	Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	The second
Root					Desc	ription of work order update		Initial	Act	tion	Sign &		THE PROPERTY OF	
Cause	1	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descr	ription	Date	Verification	QC Inspector	
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Equip/Tooling											1 y 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1			
Handling/Pre	=						l les							ž.
Material Operator							. 5							
Offset/Setup	-													
Process	\vdash													
Supplier	Н										e 10 de			
Training											5			
Transport											11.4			
Unapproved											Total Control			
2							FA	ULT CAT	TEGORY		10 12(4)	ALC: NO.		
Landi	ng G	iear				General							ELIA: SE VA	i
		Bending				Bend		Folio/P	rogram		Outside Dim	ensions	Pressure/Forced	
4		Centre No	t Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up	
	2	Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorrec	t l	Temperature/Cure	
	ni-	Crimp/Kin	k/Ripple	/Wave		Burrs		Inspecti	ion Incomplete/Ur	nqualified	Part Lost/Mi	ssing	Weld	
		Cuffs				Contamination		Instruct	ions Incomplete/L	Jnclear	Part Moved		Wrong Stock Pulled	
	-5	Crushing				Countersink		The same of the same of	ned/off center		Positioned W			T
		Heat Trea	t			Cut Too Short		Mislabe	eled		Power Loss/S		Other	
		Inspection	Strip in	Tube		Drawing		Misread	d		244			
		Marks/Ch	atter			Drill Holes	ě.	Off-set						
	_	Turning Se				Finish	.10	Out of 0	Calibration					
		Wave/Tw	st in Tub	e		Fit/Function		Out of S	Sequence					

Work Order ID 109835

Page 4

Insp.

Stamp

109835 December-03-13 8:36:22 AM Item ID: D3891-042 Accept *N900040100* Setup Start Revision ID: Stop Panel Fwd LH - Sub-Component Of#D350-766-021 Item Name: *3* Start Qty: 3.00 Start Date: 12/03/13 Cust Item ID: Required Wate: 12/10/13 Req'd Qty: 3.00 *3* Customer: Reference: Run Start Tooling: Approvals: Process Plan: Date: Date: Stop QC: Date: SPC (Y/N): Date: Operation Reject Sequence ID/ Set Up/ Accept Reject Tool ID Tool # Plan Description Code Qty Work Center ID Run Hours Qty Number 180 QC21- Final Inspection - Work Order Release 0.00 *180* QC Memo

Quality Control

0.00

DQA:		Date:						18 1 46 E				DAPT	r
					WORK ORDER NON	-CC	ONFO	RMANCE / UPDATE				AEROSPACI	E
QA Closed:		Date:			Wind Add on	3.		t e i sije-	Wo	ork Order up	date only	1 Perus particular in	
Work Orde	rı.				DISPOSITION			AGAINS	T DEI	PARTMENT	PROCESS		A COLUMN
Part N NCR N			*	_	Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Crosstube Machining Small Fal moforming Finishin Large Fab Composite	g		Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other	
Root				Descr	iption of work order update	1	nitial	Action	- 3	Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector	
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved						THE RESERVE OF THE PARTY OF THE							The state of the s
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Landir	Bending Centre No Cracks Crimp/Kin Cuffs Crushing Heat Trea Inspectio Marks/Ch Turning S	nk/Ripple it n Strip in natter	/Wave Tube		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruct Misalig Mislabe Misread Off-set	ion Incomplete/Unqualified tions Incomplete/Unclear gned/off center eled d		Outside Dimi Over/Under Part Incorrect Part Lost/Mis Part Moved Positioned W Power Loss/S	t ssing	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other	
	Wave/Tw				Fit/Function			Sequence		1.12			

Picklist Print December-113-13 8:36:25 AM Work Order ID: 109835 Parent Item: D3891-042 *D3891-042*

Parent Item Name: Panel Fwd LH - Sub-Component Of#D350-766-021

109835

Start Date: 12/03/13

Required Date: 12/10/13

Start Qty: 3.00

Required Qty: 3.00

Comments:	IPP RevA: New is	sue DD verified by:EC
Commencer	** * * *** * * * * * * * * * * * * * * *	CHE KILL THE CLESSE IN J. LES C.

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	1,613.752	3.8097	(14)412			
MI FXS 1		029-04	t						**				Jm13-12-4
GET EASTES LEARN SIL	LLI			Location		Loc	Oty	Loc Code					
				MAT019	TO STATE OF THE ST		3.752						
					124866 m126425		6.792 26.96		1-4	26425	5		
D3891-4		Manufactured	No			140	Each	3.0000	1	3		-2-2	
D3891-4	k								**		1	FF I	3-12-04

Gasket

Location	Loc Qty	Loc Code	
ST157	3		-
69380	1		
95539	2		2

Page 1

DQA:			Date:										DAPI	
						WORK ORDER NON-	-CC	ONFO	RMANCE / U		9	THE PERSON NAMED IN	AEROSPACE	E
QA Closea:		* * * * *	Date:			"First" in America		- 1		W	ork Order up	date only		
Work Orde	er:		A XA			DISPOSITION	*			AGAINST DE	PARTMENT	/PROCESS		
			Park Series			Rework			Skid-tube	Crosstube	Tally Work	Water Jet	Engineering	20
Part N	١٥				_	Scrap			Machining	Small Fab	the state of the s	d. Eng. Coor.	Quality	
N.C.						Use-as-is		Therr	noforming	Finishing	Rec/Stor	re/Packaging	Other	
NCR N	NO				- 1	Suspected Unapproved			Large Fab	Composite		Supplier		
Root					Descr	ription of work order update		nitial	\ Act	tion	Sign &			
Cause		Date	Step	Qty	Desci	or non-conformance		ief Eng		ription	Date	Verification	QC Inspector	35 75
Design		-	этер	αι,		or non comormance	CII	ici ciig	Desci	i priori	Date	Vermedien	VENT MA	
Doc/Data						The state of	1.6		100					
Equip/Tooling														
Handling/Pre														
Material							100					THE REAL PROPERTY.		
Operator							4				100		1 非理论 1 整	
Offset/Setup							in the		=				200	
Process		17									1	Mary Street		
Supplier											1			N.
Training							100						Birdine.	
Transport							18							
Unapproved											1535			103
							FAI	JLT CA	TEGORY		Mar Midely			
Landi	ng Gea					General		feer as as		_	100			
		nding	A) <u>L</u> . L.	1040	_	Bend			Program		Outside Dim		Pressure/Forced	
hi di			t Concer	itric	-	BOM/Route		Grain			Over/Under		Set-up	
in the		icks	· in-			Broken/Damage/Defect		Hardwa			Part Incorred		Temperature/Cure	
			k/Ripple,	/Wave	-	Burrs		72. 13.	ion Incomplete/Ui	The second second	Part Lost/Mi	ssing	Weld	
E .	Cu					Contamination		Carrier Francis	tions Incomplete/I	Unclear	Part Moved		Wrong Stock Pul'ed	
		ushing				Countersink	1000		gned/off center		Positioned V			
		at Treat		Tube	-	Cut Too Short		Mislabe			Power Loss/	Surge	Other	
	_	pection arks/Cha	Strip in	lube	-	Drawing Drill Holos		Misrea						
			quence			Drill Holes Finish		Off-set	Calibration					
			st in Tub	ie.	-	Fit/Function			Sequence		7/500			
				-		The state of the s		Out UI.	Jeducije					

DART AEROSPACE LTD	Work Order:	109835
Description: Panel	Part Number:	D3891-2
Inspection Dwg: D3891 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

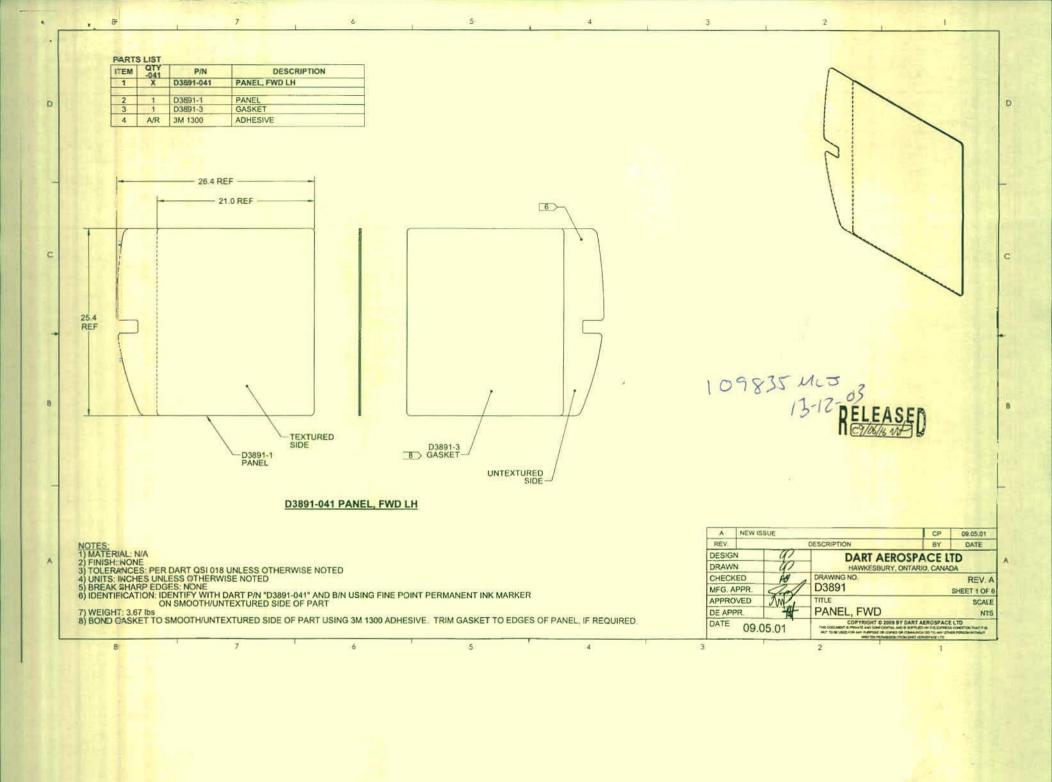
X	First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
21.6	+/-0.100	21.6			4	JAMOG
19.7	+/-0.100	19.7"			T	
2.53	+/-0.030	2.53	7		· ·	Jknor
1.25	+/-0.030	1.25"			V	
11.70	+/-0.030	11.70	-		干	
3.25	+/-0.030	3250			V	****
3.63	+/-0.030	3.63			V	
2.00	+/-0.030	2.000	-		V	
17.7	+/-0.100	17.3~			Т	*
19.6	+/-0.100	19.60			T	24 2
21.4	+/-0.100	21.4	=		T	
25.4	+/-0.100	25.4			Т	
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	N.					
						(h-
						3113

Measured by:	Jm	Audited by:	SM)	Prototype Approval:	N/A
Date:	13-12-4	Date:	13 12 04	Date:	N/A

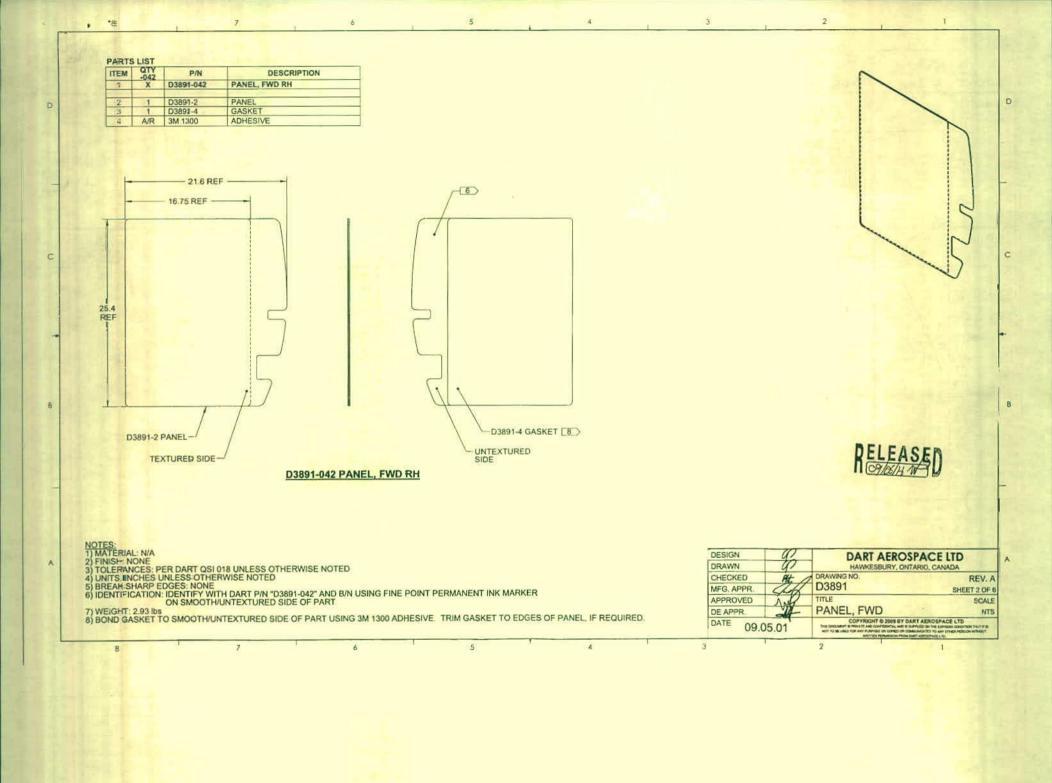
Rev	Date	Change		Revised/by	Approved
A	09.07.29	New Issue	P/O D3891-042	KJ 9	AA

DQA:			Date:			NOT								
						WORK ORDER NON	-CC	ONFO	RMANCE / UP	DATE			DARI	
QA Closed:			Date:	横		la de la companya de					ork Order up	date only] AEROSPACE	
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT/	PROCESS		
Part No.					1	Rework Scrap Use-as-is		Skid-tube Crosstube Small Fab Thermoforming Finishing			Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other		
NCRN	VO.					Suspected Unapproved		1	Large Fab	Composite		Supplier		
Root					Desc	ription of work order update	1	nitial	Actio	on	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descrip	otion	Date	Verification	QC Inspector	
Design Doc/Data					TABIS				1					
Equip/Tooling	-		400		-								5 E	
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Material		45			15.				全球工工工				-	
Operator										2				
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Supplier										5 (4.85)				
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Transport			B. 49.	100	.v		1 5 5							
Unapproved					1				MINORAL SON	100 A			3	
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		Bending		100 a 100		Bend			Program		Outside Dime		Pressure/Forced	
10	_	Centre No	t Concer	ntric		BOM/Route		Grain		THE RESIDENCE	Over/Under		Set-up	
A .	_	Cracks	t des		Te.	Broken/Damage/Defect		Hardwa			Part Incorrec		Temperature/Cure	
1		Crimp/Kin	k/Ripple	/Waster	1	Burrs			ion Incomplete/Unq		Part Lost/Mis		Weld	
	_	Cuffs				Contamination			tions Incomplete/Ur		Part Moved		Wrong Stock Pulled	
	Crushing					Countersink			gned/off center		Positioned W	_		
	Heat Treat					Cut Too Short		Mislabe			Power Loss/S	Surge	Other	
31 11	Inspection Strip in Tube					Drawing		Misrea				Temperature		
	_	Marks/Ch				Drill Holes		Off-set						
1	_	Turning Se				Finish	Out of Calibration					The second second		
	111	Wave/Twi	ist in Tub	e		Fit/Function	Out of Sequence							

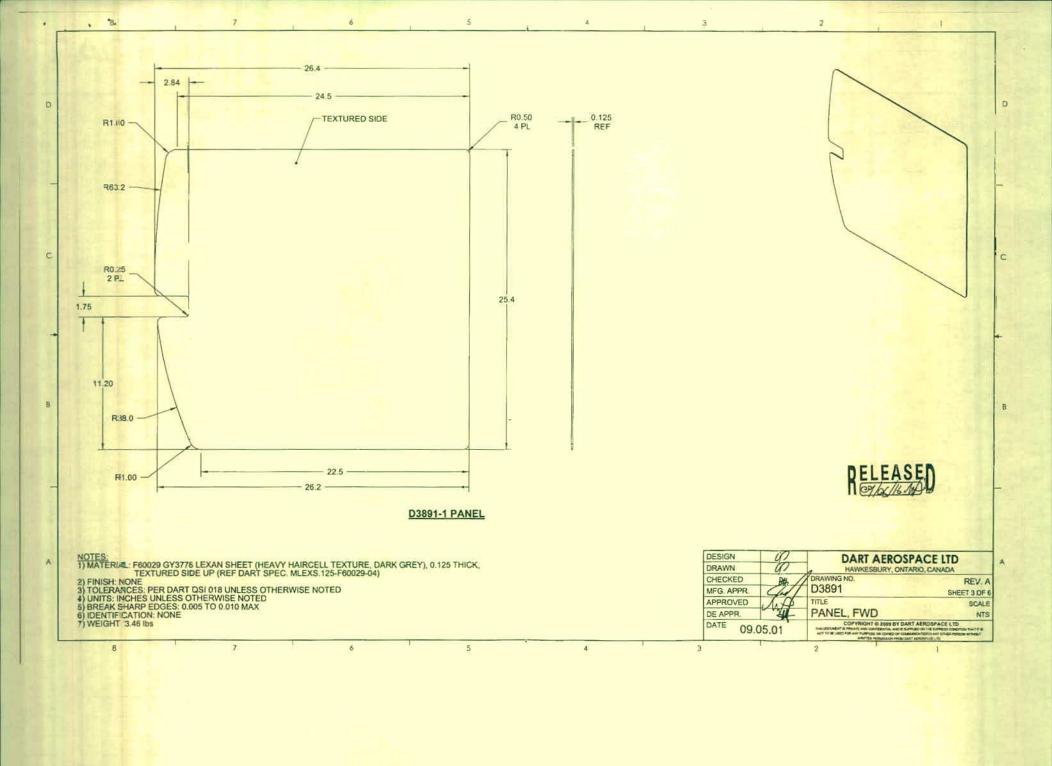


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						WORK ORDER NON	-CC	ONFO	RMANCE / U				AEROS	PACE
QA Closed:			Date:							W	ork Order ap	date only	The Man	
Work Orde	er:					DISPOSITION	4	ng Sie		AGAINST DE	PARTMENT	/PROCESS		bil
50 100						Rework Skid-tube Crosstube						Water Jet	Engineering	
Part N	۷o					Scrap	6		Machining	Small Fab	-	d. Eng. Coor.	Quality	
						Use-as-is		Thern	noforming	Finishing	Rec/Stor	re/Packaging	Other	
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Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspec	tor
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Material							3111							
Operator							10					1		40
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Supplier	Н										11 5 11 11			47
Training	Н													
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Unapproved							L				100 A 18			##
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		Cuffs				Contamination	-		tions Incomplete/I	Unclear	Part Moved		Wrong Stock P	ulled
	Crushing					Countersink	-		gned/off center	_	Positioned W			
	Heat Treat				-	Cut Too Short		Mislabe		L	Power Lass/	Surge	Other	
â	Inspection Strip in Tube				-	Drawing		Misread			13/5			
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		Turning St			-	Finish			Calibration					170.00
I I I at	1 1	Wave/Tw	ist in Tub	e e		Fit/Function		Out of Sequence						

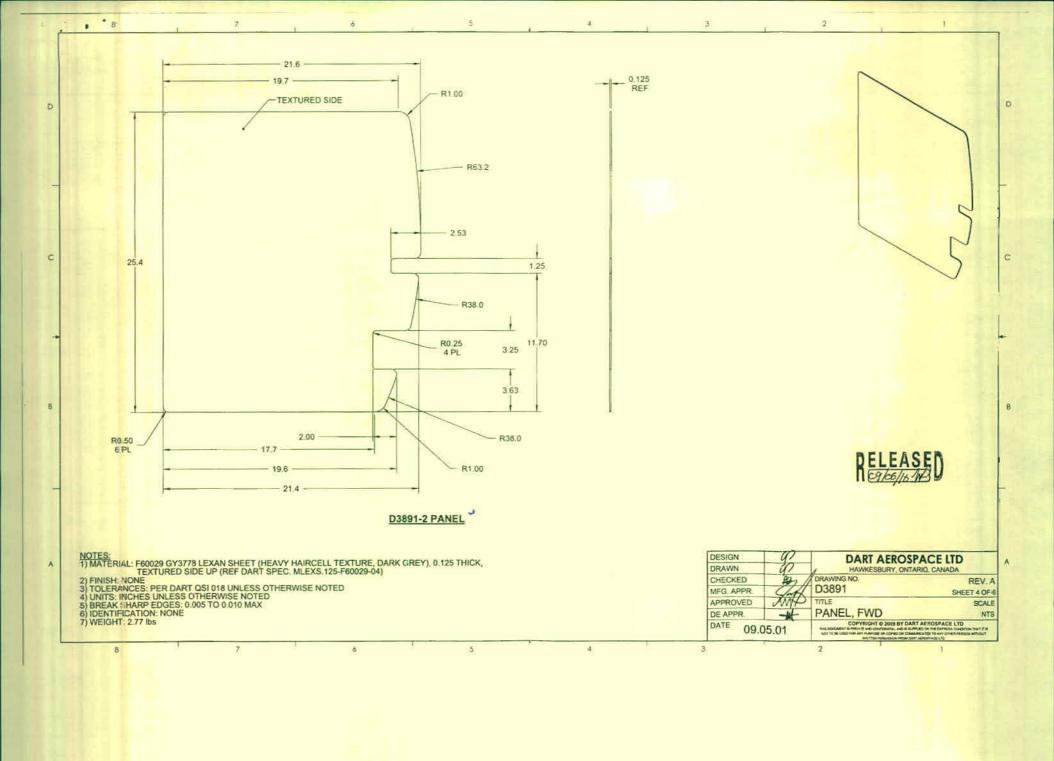
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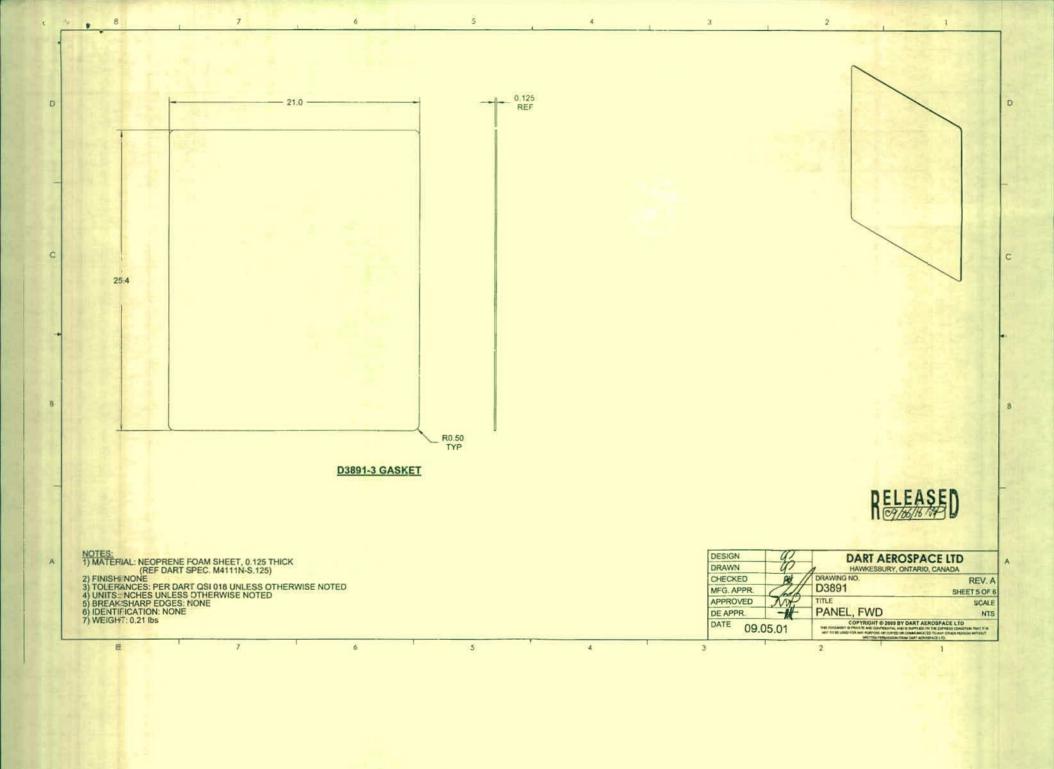
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					WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE		1.0		DARI		
QA Closed:	Zbr.	Date:	i i				200	/#	W	ork Order up	date only			
Work Orde	er:	4.3			DISPOSITION			AGAINS	T DE	PARTMENT	PROCESS /			
Part N				_	Rework Skid-tube Crosstu Scrap Machining Small F Use-as-is Thermoforming Finishi Suspected Unapproved Large Fab Compos				ab Prod. Eng. Coor. Qualit					
Root	-	7		Dosc	ription of work order update		nitial	Action	70	Cian 0				
Cause	Date	Step	Qty	Desc	or non-conformance		initial iief Eng			Sign & Date	Verification	QC Inspector		
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	Bending				Bend	V	Folio/F	Program		Outside Dim	ensions	Pressure/Forced		
		Not Conce	ntric		BOM/Route		Grain		750	Over/Under		Set-up		
	Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorrec		Temperature/Cure		
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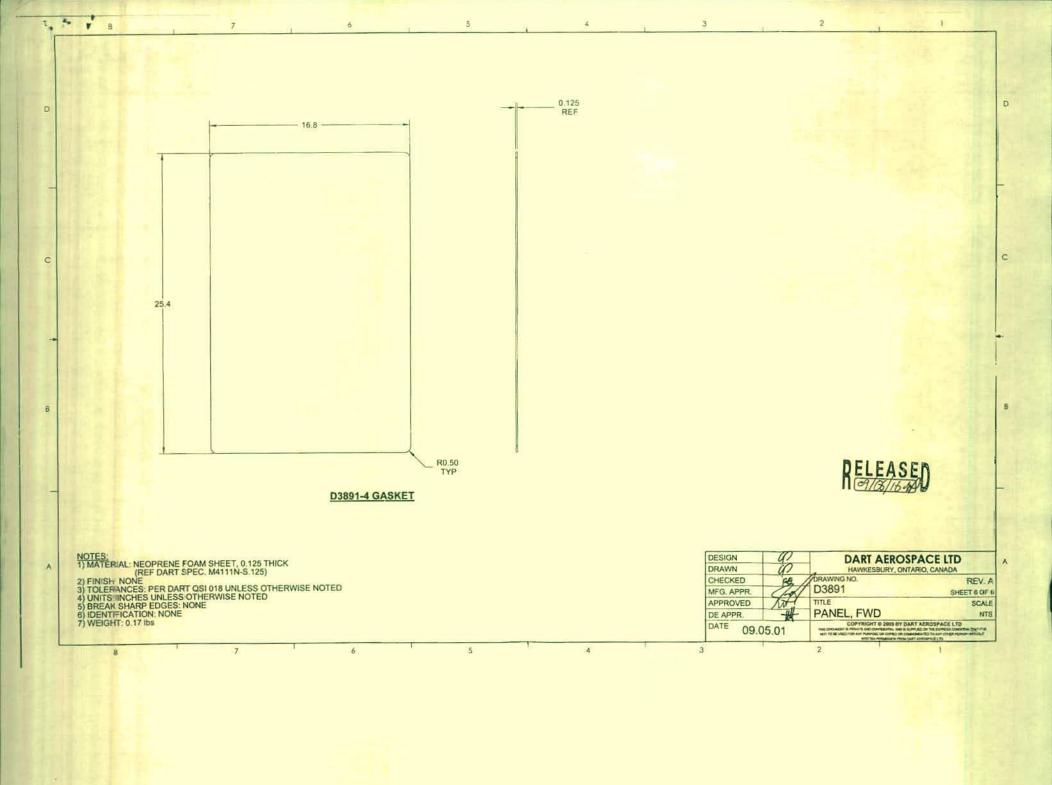
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